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<p>(54) Title: ADJUVANT COMPOSITION FOR CHEMICALS USED IN AGRICULTURE</p> <p>(57) Abstract</p> <p>According to the invention an adjuvant for use with a chemical used in agriculture is provided comprising: (a) not in excess of about 75 % by weight of one or more lipophilic solvents; (b) not in excess of about 50 % by weight of one or more plant nutrients (e.g. ammonium salts of inorganic anions); and (c) not in excess of about 50 % of a mixture of one or more cationic emulsifiers including surfactants which exhibit cationic characteristic in acidic conditions.</p>		

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## Adjuvant Composition for Chemicals Used in Agriculture

### Field of the invention

The invention relates to an adjuvant for use with chemicals used in agriculture. More particularly, the adjuvant of the invention is particularly adapted for use with herbicides.

### Background of the invention

Whilst the following discussion highlights the invention with relation to herbicides, it is believed that the same principles apply to other chemicals used in agriculture, such as, plant hormones, insecticides, crop desiccants or crop defoliant.

10 Farmers rotate the use of their fields to allow the fields to regain their fertility. This means that at any one time there will be fields with crops and fields left bare. The bare fields are said to be fallow fields.

Weeds will still grow on the fallow fields, and while they will not be competing with a crop for nutrients or space, if they are left alone they will produce many seeds which will germinate and be a problem when the field is again used for crops. As a result, the farmer will spray the fallow fields with herbicide to kill the weeds. Since there is no crop on fallow fields, a non-selective herbicide can be used, such as glyphosate. Non-selective herbicides can also be used to control weeds in cropping situations where the crop has either been bred or genetically modified to be resistant to the herbicide.

20 There is a growing trend to produce adjuvants to improve the efficacy of agrochemicals, including herbicides. For example, in Australian patent application number 62833/98, an adjuvant for use with herbicides, crop defoliant and desiccant is disclosed including esters of fatty acids and nonionic emulsifiers.

Glyphosate is the most widely used non-selective herbicide for both fallow and cropping situations worldwide. Currently, a farmer may prepare the glyphosate spray with several additives to improve its efficacy. For example, it is known to add ammonium salts to improve the efficacy of glyphosate. The reasons for this improvement are not well understood and it is a complicated area of chemical and botanical reactions. However, it is believed that some anions can minimize the deleterious effect of hard water on

herbicidal performance and the ammonium cation provides nutrition for the plant which enhances the uptake and translocation of the herbicide by the plant. Wetting agents are also used to improve leaf coverage. Petroleum fractions or other lipophilic materials (hereinafter referred to as lipophilic solvents) are used, especially in the summer  
5 months, to keep the herbicide in liquid form as the herbicide will be ineffective once it dries on the foliage.

The farmer may combine all these additives with the herbicide when the tank mix is prepared but the farmer may not know whether these components are compatible with each other. Some additives or adjuvants can actually antagonise each other and decrease  
10 the activity of the agrochemical. It is also inconvenient since there are several components which must be bought, measured and combined.

Farmers are always looking for more efficacious and convenient ways to enhance the performance of active ingredients. They would also prefer to simply add one composition which they know will enhance the efficacy of the herbicide rather than deal  
15 with several components where the resultant effect is unknown.

### **Summary of the invention**

It was envisaged that incorporating ammonium salts into lipophilic solvent-based adjuvants would produce an adjuvant which provides active ingredient enhancement in several different ways. It was thought that the ammonium salts (a source of nitrogen)  
20 would enhance translocation through the fertilizer effects and could also increase leaf permeability, and the appropriate anion would reduce the effects of water hardness, whilst the lipophilic solvents would increase the availability of the active on the target and subsequently the absorption of the active into the target. However, preparing a stable homogeneous blend of lipophilic solvent with ammonium salts, particularly those  
25 which minimize the detrimental effects of hard water has not been easy to achieve because such salts are not soluble in lipophilic solvents. Hence, evaluating such a product as an adjuvant has not been possible.

It has been found that a homogeneous blend which is stable within normal storage conditions can be made which includes lipophilic solvents and plant nutrients (such as  
30 ammonium salts) using cationic emulsifiers as a coupling agent.

According to the invention, an adjuvant for use with a chemical used in agriculture is provided comprising:

- (a) not in excess of about 75% by weight of one or more lipophilic solvents;
- (b) not in excess of about 50% by weight of one or more plant nutrients (such as ammonium salts of inorganic anions); and
- (c) not in excess of about 50% of a mixture of one or more cationic emulsifiers including surfactants having cationic characteristics in acidic conditions.

Preferably, the adjuvant comprises:

- (a) from 5 to 55% by weight of one or more lipophilic solvents;
- (b) from 1 to 30% by weight of one or more plant nutrients (such as ammonium salts of inorganic anions); and
- (c) from 1 to 15% of a mixture of one or more cationic emulsifiers including surfactants having cationic characteristics in acidic conditions.

More preferably, the adjuvant comprises:

- (a) from 15 to 35% by weight of one or more lipophilic solvents;
- (b) from 5 to 25% by weight of one or more plant nutrients (such as ammonium salts of inorganic anions); and
- (c) from 1 to 10% of a mixture of one or more cationic emulsifiers including surfactants having cationic characteristics in acidic conditions.

- The above proportions are based on the dry weight of the plant nutrients and cationic emulsifiers. It is common for these products to be supplied in aqueous or other diluted forms. It will be necessary to determine actual concentrations of these components prior to using these diluted products in a composition according to the invention.

The lipophilic solvents may be petroleum fractions, vegetable oils, synthetic triglycerides, alkyl esters of fatty acids, fatty alcohols, guerbet alcohols or any mixture thereof. Preferably, a petroleum fraction is used as it is more cost effective. More preferably, the petroleum fraction is a mineral oil. These mineral oils, for example, can be 70, 100 or 150 sec solvent neutral.

If alkyl esters of fatty acids are used then the higher levels of unsaturated fatty acids are preferred, being more effective as modifiers of the waxy layers on weed surfaces. The alkyl moiety can be derived from the simple alcohols such as methyl-, ethyl- or propyl alcohols. There are innumerable variations of the esters of fatty acids which may be produced from the natural oils and fats such as lard, tallow and vegetable oils, such as canola, corn, sunflower and soyabean oils, or from specific blends produced by fatty acid manufacturers or from fatty acids produced by synthetic means.

The plant nutrients include ammonium salts of inorganic anions (such as ammonium sulphate and phosphates) which are known to minimise the deleterious effects of hard water on herbicide performance. Preferably, the ammonium salt is ammonium sulphate. If an anhydrous ammonium salt is used then water may need to be added to the composition. However, if the ammonium salt is already in solution then additional water may not be necessary.

The term "cationic emulsifiers" is used to include emulsifiers which are commonly classified as cationic as well as those which exhibit cationic properties in acidic conditions. An example of an emulsifier which is commonly classified as cationic is a quaternary cationic emulsifier. Examples of emulsifiers which exhibit cationic properties in acidic conditions are fatty amines, amine oxides and amine ethoxylates. Amphoteric emulsifiers such as betaines may also exhibit such properties.

Preferably, the cationic emulsifiers are selected from dimethylcocoamine, dimethyl-laurylamine oxide, alkyltrimethylammonium chloride, alkyl dimethylbenzylammonium chloride, alkylpyridium chloride, alkylimidazolium chloride, or mixtures thereof. More preferably, the cationic emulsifier is selected from alkyltrimethylammonium chloride, dimethyl lauryl amine oxide or mixtures thereof.

Preferably, the adjuvant composition comprises other components to improve the form of the composition. These other components may be added to form a micro-emulsion. The other components may be selected from the group consisting of nonionic emulsifiers, co-solvents and mixtures thereof.

Preferably, the nonionic emulsifiers are alkyl polysaccharides, sorbate emulsifiers, alkyl bearing ethoxylates or fatty alkanolamides. Alkyl polysaccharides are sometimes called

alkyl polyglucosides, alkyl glucosides or alkyl saccharides. The sorbate emulsifiers are sorbitan mono- (or sesqui-) esters of fatty acids and include sorbitan mono-oleate and sorbitan monolaurate. Preferably, the sorbate emulsifier is sorbitan mono-oleate. An example of a fatty alkanolamide is oleyldiethanolamide. The co-solvents include  
5 propylene glycol, 1,3-butanediol, hexylene glycol, polypropylene glycols and ethanol. Anionic emulsifiers may be added when compatible with the other components.

When mineral oils are used as the lipophilic solvent and ammonium sulphate is used as the plant nutrient, preferably, the composition comprises a cationic emulsifier, the following nonionic emulsifiers: alkylpolysaccharides, fatty alkanolamide and sorbitan mono-oleate or  
10 alcohol ethoxylate, as well as the following co-solvents: 1,3-butanediol and ethanol.

When esters of fatty acids are used as the lipophilic solvent, preferably, a mixture of at least two cationic emulsifiers are used. One of the cationic emulsifiers may be an amphoteric emulsifier acting as a cationic emulsifier. More preferably, the mixture of cationic emulsifiers comprises fatty quaternary ammonium chlorides or fatty amine oxides  
15 in conjunction with fatty alkyldimethylamine salts of simple organic acids. For example, the fatty alkyldimethylamine salts of simple organic acids could be cocodimethylamine or lauryldimethylamine with citric acid. Other simple organic acids include acetic, 2-ethylhexanoic acid, tartaric, maleic and lactic acid.

In another preferred form of the invention, the adjuvant for use with a chemical used in  
20 agriculture further comprises one or more other available adjuvant components. The adjuvant component may be selected from pH modifiers, spray drift retardants, stickers, rainfasteners and wetters.

According to another embodiment of the invention, there is provided an agrochemical composition comprising a chemical used in agriculture and an activity enhancing amount  
25 of an adjuvant, said adjuvant comprising:

- (a) not in excess of about 75% by weight of one or more lipophilic solvents;
- (b) not in excess of about 50% by weight of one or more plant nutrients (such as ammonium salts of inorganic anions); and
- (c) not in excess of about 50% of a mixture of one or more cationic emulsifiers  
30 including surfactants which exhibit cationic characteristics in acidic conditions.

According to a further embodiment of the invention, there is provided an adjuvant when used with a chemical used in agriculture comprising:

- (a) not in excess of about 75% by weight of one or more lipophilic solvents;
- (b) not in excess of about 50% by weight of one or more plant nutrients (such as ammonium salts of inorganic anions); and
- (c) not in excess of about 50% of a mixture of one or more cationic emulsifiers including surfactants which exhibit cationic characteristics in acidic conditions.

According to an even further embodiment of the invention, there is provided a method for enhancing the activity of a chemical used in agriculture comprising the step of combining the chemical with an adjuvant comprising:

- (a) not in excess of about 75% by weight of one or more lipophilic solvents;
- (b) not in excess of about 50% by weight of one or more plant nutrients (such as ammonium salts of inorganic anions); and
- (c) not in excess of about 50% of a mixture of one or more cationic emulsifiers including surfactants which exhibit cationic characteristics in acidic conditions.

According to another embodiment of the invention, there is provided a method of treating vegetation comprising the step of applying an agrochemical composition comprising a chemical used in agriculture and an adjuvant comprising:

- (a) not in excess of about 75% by weight of one or more lipophilic solvents;
- (b) not in excess of about 50% by weight of one or more plant nutrients (such as ammonium salts of inorganic anions); and
- (c) not in excess of about 50% of a mixture of one or more cationic emulsifiers including surfactants which exhibit cationic characteristics in acidic conditions.

### Examples

- The invention will now be further explained and illustrated by the following non-limiting examples.

### Lipophilic solvents, cationic emulsifiers, plant nutrients and other components used



1,3 Butanediol	ex Hoechst Celanese, USA
'880' ammonia	ex Orica, Australia
Acetic acid glacial	ex Orica, Australia
Algene SC25	25% paste of stearyl dimethyl benzyl ammonium chloride ex ICI Ltd, UK
Alkadet 15	70% solution of alkyl polysaccharide ex Huntsman Corporation, Australia
Ammonium nitrate	> 99% purity ex Orica, Australia
Ammonium sulphate	>99% purity ex Redox, Australia
BS 1000	commercial adjuvant containing alcohol alkoxylate ex Cropcare, Australia
Cation BB	lauryl trimethyl ammonium chloride in a 30% solution containing salt ex AMTRADE Australia
Citric acid	ex Citrique Belge, Belgium
Dimethyl cocoamine	ex Proctor & Gamble, USA
Dimethyl laurylamine	ex Fina Chemicals, Belgium
Empigen BB	28% solution of cocobetaine ex Albright and Wilson, Australia
Ethanol	ex CSR, Australia and contains 2-3% methanol.
Ethyl oleate	ex Victorian Chemical Company, Australia and contains approximately 80% w/w ethyl and 20% w/w methyl esters of canola oil.
Glyphosate CT solution	commercial herbicide containing 450 g/L glyphosate ex Nufarm, Australia
HASTEN	commercial adjuvant containing 704 g/l ethyl oleate ex Victorian Chemical Company, Australia

Lactic acid	88% solution ex Musashima, Japan
Liase	commercial adjuvant containing 417 g/l ammonium sulphate ex Nufarm, Australia
LI700	commercial adjuvant containing 345 g/l phospholipids and 355g/l propionic acid ex Nufarm, Australia
Lorol C1298	Lauryl alcohol ex Henkel, Australia
Oleylamine	ex Fina Chemicals, Belgium
Oxamin LO	30% solution of lauryldimethylamine oxide ex Huntsman Corporation, Australia
Potassium ammonium phosphate	46% aqueous solution ex Wilbur Ellis Company, USA
Propylene glycol	industrial grade ex Dow Chemicals, Australia
Prorex 36	100 sec solvent neutral mineral oil ex Mobil, Australia
Quatramine C16/29	29% solution of cetyltrimethyl-ammonium chloride ex APS Chemicals, Australia
Quatramine NC50	50% solution of alkyldimethylbenzyl ammonium chloride ex APS Chemicals, Australia
Radiaquat 6465	30% solution of lauryl trimethyl ammonium chloride ex Fina Chemicals, Belgium
Roundup CT Xtra	commercial herbicide containing 490 g/L glyphosate ex Monsanto, Australia
Shell P830	paraffinic 70 sec oil ex Shell, Australia
Span 80	sorbitan mono-oleate ex Huntsman Corporation, Australia
Teric N2	nonylphenol 2 moles ethylene oxide ex Huntsman Corporation, Australia

Teric N9	nonylphenol 9 moles ethylene oxide ex Huntsman Corporation, Australia
Terwet 3001	70% solution of alkyl polysaccharide ex Huntsman Corporation, Australia
Tridecanol	ex Shell Chemicals, Australia
Urea	ex Orica, Australia
Vicamid 825	oleyldiethanolamide ex Victorian Chemical Company, Australia
VOC RHT 100	paraffinic 100 sec oil ex Safety Kleen, USA
Winter Oil	commercial adjuvant containing emulsified mineral oil ex BP, Australia

### Example 1

In this example, low levels of glyphosate were used to treat a broadleaf weed and a grass weed.

#### 5 Adjuvant compositions tested

The following adjuvant formulations were prepared and are stable compositions. A formulation was classified as stable if it remained a clear liquid without detectable phase separation for at least 48 hours through the temperature range 0 to 40°C. Adjuvant D which is an oil-in-water emulsion was only tested at room temperature.

10 The proportions are shown as percentage by weight.



The above adjuvants were tested by combining the adjuvant with Glyphosate CT in a water-based tank mix. Compositions 2 to 14 below are spray tank mixtures containing glyphosate and other components as listed.

The spray tank mixture was applied to the plants at a rate equivalent to 64 litres/hectare.

- 5 The glyphosate used was the commercially available Glyphosate CT at a rate equivalent to either 60 g a.i./hectare or 120 g a.i./hectare which is 12.5% and 25% respectively of the normal application rate. The adjuvants were added volumetrically to the tank mix as a percentage of the tank mix volume.

**Compositions tested.**

Composition	Other Components
1.	unsprayed control
2.	no other components
3.	0.2% BS 1000
4.	1.0% Winter Oil
5.	2.0% Liase
6.	0.2% BS 1000, 1.0% Winter Oil and 2.0 % Liase
7.	0.75% of Adjuvant A
8.	1.5% of Adjuvant A
9.	0.75% of Adjuvant B
10.	1.5% of Adjuvant B
11.	0.75% of Adjuvant C
12.	1.5% of Adjuvant C
13.	0.75% of Adjuvant D
14.	1.5% of Adjuvant D

**Spiny Emex**

The above compositions were tested on spiny emex shoots which is a broad leaf weed. The level of effectiveness of each composition was determined using the fresh weight of the weed 31 days after the spray application. The results are an average of seven  
 5 replicates.

The lower the fresh weight of the weed the more effective the composition.

**Test results with spiny emex shoots**

Composition	Fresh weight (g)	
	(60 g/ha glyphosate)	(120 g/ha glyphosate)
1. (control)	15.1	15.1
2.	14.0	9.8
3.	13.2	8.5
4.	12.1	7.1
5.	11.0	6.5
6.	13.0	8.8
7.	12.2	5.3
8.	10.8	5.0
9.	7.9	4.0
10.	6.1	3.5
11.	10.8	6.8
12.	6.9	4.2
13.	9.2	3.0
14.	5.5	3.6

### Analysis

These results illustrate that when using low levels of glyphosate on a broadleaf weed, Compositions 7 to 14 are more efficient than Composition 2 which is glyphosate alone therefore Adjuvants A to D are acting as adjuvants. At 120g/ha, Compositions 7 to 14  
5 are significantly better than Composition 2. At 60g/ha, the effectiveness of Compositions 7 to 14 depended on the amount of adjuvant used and the composition of the adjuvant. Adjuvants B and D had superior results at both concentrations.

Compositions 7 to 14 compared favorably to Compositions 3 to 6 which contain commercially available adjuvants. At 120g/ha, Compositions 7 to 10 and 12 to 14 had  
10 superior results to Compositions 3 to 6. At 60 g/ha, depended on the adjuvant used and the amount of adjuvant used. Adjuvants B and D had superior results at both concentrations.

Compositions 7 to 14 are also more efficient than the mere combination of additives in Composition 6. Therefore, the invention provides an adjuvant for a herbicide in a single  
15 homogeneous composition which is more effective than the mixture which a farmer would obtain if the commonly used additives were simply mixed together in the tank mix.

### **Ryegrass**

The above compositions were tested on ryegrass shoots which is a grass. The fresh  
20 weight (grams) of the weeds were measured 19 days after the spray application. The results are an average of eight replicates.

**Test results for ryegrass shoots**

Composition	Fresh weight (g)	
	(60 g/ha glyphosate)	(120 g/ha glyphosate)
1.	4.0	4.0
2.	3.0	2.0
3.	3.75	0.75
4.	3.5	0.75
5.	2.0	1.0
6.	2.0	1.0
7.	3.5	1.5
8.	2.75	1.0
9.	1.75	0.5
10.	1.25	0.25
11.	1.75	0.5
12.	1.75	0.25
13.	2.25	0.25
14.	1.25	0.25

**Analysis**

These results illustrate that Compositions 9 to 14 are clearly more efficient than  
5 Composition 2 which is glyphosate alone and thus that Adjuvants B, C and D are acting  
as adjuvants.

Compositions 9 to 14 compared favorably to Compositions 3 to 6. The results depended  
on the adjuvant used and the amount of adjuvant used.



At the lowest glyphosate level (60g/ha) the best results were achieved with Adjuvants B and D at the higher rates (Compositions 10 and 14). These compositions are clearly more efficient than Compositions 3 to 6.

At the higher glyphosate level (120g/ha). Compositions 9 to 14 are clearly more efficient than Compositions 3 to 6. Adjuvants B, C and D had superior results.

Adjuvant A (represented by Compositions 7 and 8) was less effective on ryegrass shoots at the lower glyphosate level but of comparable performance as Compositions 5 and 6 at the higher glyphosate level.

### Example 2

In this example, the effect of external conditions and hard water are tested. Hard water has been shown to reduce the efficacy of glyphosate. Higher temperatures increase the evaporation rate of the spray water and thereby can leave the glyphosate dry on the foliage rendering it less available for absorption into the plant.

Water hardness is measured in World Health Organisation units of hardness (WHO). One WHO is equivalent to 343 ppm of  $\text{CaCO}_3$ .

The test compositions were tested on ryegrass using water of three differing degrees of hardness: Melbourne tap water (typically 20 ppm), 1WHO and 3WHO water. The fresh weight (grams) of the weeds were measured 19 days after spray application. The results are an average of seven or eight replicates.

The test compositions were tested on ryegrass exposed to two differing environmental temperature conditions (Standard and Hot) for one hour before and two hours after spraying. Standard temperature was that of the controlled greenhouse (approximately 20°C) whereas Hot temperature was induced in a 30°C constant environment room. The fresh weight of the weeds was measured 21 days after spraying. The results are an average of eight replicates.

The following adjuvants are stable compositions and were tested in Example 2.

Component		Adjuvant	
		E	F
Lipophilic solvent	Prorex 36	22	21
Plant nutrient	Ammonium Sulphate	15	14
	Water	30	30
Cationic Emulsifier	Quatramine C16/19	12	7
	Algene SC25	-	7
Other Components	1,3 Butanediol	4	4
	Ethanol	2	2
	Span 80	6	6
	Terwet 3001	6	6
	Vicamid 825	3	3

The above adjuvants were tested by combining the adjuvant with Glyphosate CT in a water-based tank mix. Compositions 16 to 23 are spray tank mixtures containing  
 5 glyphosate and other components as listed.

The glyphosate was applied at 120g ai/ha (25% of the normal application rate).

Composition	Other Components
15.	unsprayed control
16.	no other components
17.	0.25% LI700
18.	0.25% Adjuvant E
19.	1.0% Adjuvant E
20.	0.25% Adjuvant F
21.	0.1% BS1000 and 2.0% Liase
22.	0.25% HASTEN
23.	Roundup CT Xtra (used in place of Glyphosate CT to provide an equivalent amount of glyphosate)

#### Test results for ryegrass shoots

Composition	Tap/ Standard	1WHO	3WHO	Hot
15.	1.726	1.726	1.726	1.726
16.	0.292	0.871	1.696	0.455
17.	0.401	0.487	1.185	0.647
18.	0.139	0.364	1.571	0.315
19.	0.157	0.184	0.312	0.173
20.	0.199	0.425	1.057	0.315
21.	0.127	0.130	0.158	0.266
22.	0.186	0.325	1.588	0.223
23.	0.264	0.534	1.684	0.293

### Effect of Water Hardness

The results for Compositions 16 and 23 clearly indicate that hard water reduces the efficacy of glyphosate. Composition 21 illustrates that the use of ammonium sulphate  
5 improves the performance of glyphosate in hard water. Composition 19 which contains an adjuvant according to the invention achieved excellent results in all of the conditions. Compositions 18 and 20 illustrate that to achieve the suitable results a sufficient amount of adjuvant must be used such as that in Composition 19.

Adjuvant E (in Composition 19) is clearly effective as an adjuvant for reduced levels of  
10 glyphosate on ryegrass in the presence of hard water. As with Liase and other ammonium sulphate bearing adjuvants, the amount of Adjuvant E must be adjusted to meet the degree of water hardness.

### Effect of Temperature Conditions

The performance of glyphosate is clearly reduced in Hot conditions. Compositions 18  
15 and 20 contained 0.25% of an adjuvant according to the present invention and achieved comparable results to the known additives. Composition 19 which contained 1.0% of an adjuvant according to the invention continued to perform well under Hot conditions. Under Hot conditions, Composition 19 actually performed as well as compositions with known additives under Standard conditions.

20 The Hot conditions resulted in higher fresh weights. Composition 19 clearly resisted this decrease in performance in a satisfactory manner. Adjuvant E (in Compositions 18 and 19) is clearly effective as an adjuvant for reduced levels of glyphosate on ryegrass in Hot conditions when used in appropriate amounts.

### Example 3

25 This example investigated the formulation stability when another typical adjuvant component is added. The additional component tested was BIVERT concentrate which is the active ingredient of BIVERT, a spray drift retardant ex Wilbur-Ellis Company.

The following compositions were prepared as homogeneous blends. All proportions are by weight. All the ingredients except for the citric acid were stirred together. Then

enough citric acid was then added with stirring to clear the mixture and give high temperature stability.

Each of the adjuvants G, H and I were found to be homogeneous blends which remained clear without phase separation for at least 48 hours through the temperature range 0 to 40°C.

#### Adjuvant compositions with spray drift retardant

Component		Adjuvant		
		G	H	I
Lipophilic solvent	Ethyl oleate	30	30	30
Plant nutrient	Ammonium sulphate	-	-	10
	Potassium ammonium phosphate	20	20	-
	Water	10	10	20
Cationic Emulsifier	Dimethyl laurylamine	10	10	10
	Quatramine C16/29	-	6	6
	Radiaquat 6465	5	-	-
Other Components	Alkadet 15	5	5	5
	BIVERT concentrate	10	10	10
	Citric acid	2	2	2
	Propylene Glycol	5	3	3
	Vicamid 825	5	4	4

#### Example 4

A series of formulations were developed to test their stability. It was found that each of the following formulations are stable compositions or semi-stable emulsions at ambient temperature. All proportions are by weight.

Other components	Vicamid 825	-	-	-	-	-	-	-
	Terwet 3001	-	-	-	-	-	-	-
	Teric N9	-	-	-	-	-	-	-
	Span 80	7	-	-	-	-	-	-
	Propylene glycol	-	-	-	-	-	-	-
	Oleylamine	-	-	-	-	-	5	-
	Lactic acid	-	-	1	-	3	-	-
	Ethanol	-	-	-	-	-	-	-
	Citric acid	-	-	-	1	-	-	-
	Alkadet 15	4	-	-	-	-	-	-
	Acetic Acid	-	-	-	-	-	1	-
	'880' ammonia	-	-	-	-	-	-	-
	1,3 butanediol	-	-	-	-	-	-	-
Cationic emulsifier	Radiaquat 6465	11	-	-	-	10	-	-
	Quatramine NC50	-	-	-	-	-	15	-
	Quatramine C16/29	-	-	-	-	-	-	-
	Oxamin LO	-	-	-	-	-	-	-
	Empigen BB	-	-	-	-	-	-	-
	Dimethyl laurylamine	-	-	-	-	10	-	-
	Dimethyl cocoamine	-	-	10	10	-	-	-
	Cation BB	-	-	-	-	-	-	15
	Algene SC25	-	20	-	-	-	-	-
Plant nutrient	Added Water	38	30	30	30	40	30	50
	Urea	-	-	-	-	-	-	-
	Ammonium sulfate	17	10	10	10	10	15	10
	Ammonium nitrate	-	-	-	-	-	-	-
Lipophilic solvent	VOC RHT 100	-	-	-	-	-	-	-
	Tridecanol	-	-	-	-	-	-	10
	Shell P830	-	-	-	-	-	-	-
	Prorex 36	22	38	-	50	60	-	-
	LOROL C1298	-	2	-	-	-	-	15
	Ethyl oleate	-	-	50	-	-	35	-
Adjuvant		J	K	L	M	N	O	P

Other components	Vicamid 825	11.5	9	7.5	90	2	2	2
	Terwet 3001	-	-	-	70	-	-	-
	Teric N9	-	-	-	25	-	-	-
	Span 80	-	-	-	-	11	10	10
	Propylene glycol	7	10	-	-	-	-	-
	Oleylamine	-	-	-	-	-	-	-
	Lactic acid	-	-	-	-	-	-	-
	Ethanol	-	-	-	25	-	-	-
	Citric acid	2.5	1-1.5	1-1.5	-	-	-	-
	Alkadet 15	5	5	5	-	6	7	7
	Acetic Acid	-	-	-	-	-	-	-
	'880' ammonia	-	-	-	5	-	-	-
Cationic emulsifier	1,3 butanediol	-	-	5	40	1	1	2.5
	Radiaquat 6465	-	-	-	-	-	-	-
	Quatramine NC50	-	-	-	-	-	-	-
	Quatramine C16/29	-	10	10	130	-	-	-
	Oxamin LO	-	-	-	-	-	-	-
	Empigen BB	10	10	10	-	-	-	-
	Dimethyl laurylamine	10	-	-	-	-	-	-
	Dimethyl cocoamine	-	-	-	5	-	-	-
	Cation BB	-	-	-	-	16	14	15
Plant nutrient	Algene SC25	-	-	-	-	-	-	-
	Added Water	20	20	20	200	58	43	57
	Urea	-	-	-	100	-	-	-
	Ammonium sulfate	10	10	10	-	25	20	24
Lipophilic solvent	Ammonium nitrate	-	-	-	100	-	-	-
	VOC RHT 100	-	-	-	-	-	-	37
	Tridecanol	-	-	-	-	-	-	-
	Shell P830	-	-	-	-	-	43	-
	Prorex 36	-	-	-	-	34	-	-
	LOROL C1298	-	-	-	-	-	-	-
Adjuvant	Ethyl oleate	30	30	30	240	-	-	-
		Q	R	S	T	U	V	W

Other components	Vicamid 825	11	12
	Terwet 3001	22	25
	Teric N9	-	-
	Span 80	22	23
	Propylene glycol	-	-
	Oleylamine	-	-
	Lactic acid	-	-
	Ethanol	6	4
	Citric acid	-	4
	Alkadet 15	-	-
	Acetic Acid	-	-
	'880' ammonia	-	-
Cationic emulsifier	1,3 butanediol	15	15
	Radiaquat 6465	-	-
	Quatramine NC50	-	-
	Quatramine C16/29	-	-
	Oxamin LO	71	70
	Empigen BB	-	-
	Dimethyl laurylamine	-	-
	Dimethyl cocoamine	-	-
	Cation BB	-	-
Plant nutrient	Algene SC25	-	-
	Added Water	121	81
	Urea	-	-
	Ammonium sulfate	55	60
Lipophilic solvent	Ammonium nitrate	-	-
	VOC RHT 100	-	-
	Tridecanol	-	-
	Shell P830	-	-
	Prorex 36	77	80
	LOROL C1298	-	-
Adjuvant	Ethyl oleate	-	-
		X	Y



The word 'comprising' and forms of the word 'comprising' as used in this description and in the claims does not limit the invention claimed to exclude any variants or additions.

5 Modifications and improvements to the invention will be readily apparent to those skilled in the art. Such modifications and improvements are intended to be within the scope of this invention.

**THE CLAIMS DEFINING THE INVENTION ARE AS FOLLOWS:**

1. An adjuvant for use with a chemical used in agriculture comprising:
  - (a) not in excess of about 75% by weight of one or more lipophilic solvents;
  - (b) not in excess of about 50% by weight of one or more plant nutrients; and
  - 5 (c) not in excess of about 50% of a mixture of one or more cationic emulsifiers including surfactants having cationic characteristics in acidic conditions.
2. An adjuvant according to claim 1 comprising:
  - (a) from 5 to 55 % by weight of one or more lipophilic solvents;
  - 10 (b) from 1 to 30 % by weight of one or more plant nutrients; and
  - (c) from 1 to 15% of a mixture of one or more cationic emulsifiers including surfactants having cationic characteristics in acidic conditions.
3. An adjuvant according to claim 2 comprising:
  - (a) from 15 to 35% by weight of one or more lipophilic solvents;
  - 15 (b) from 5 to 25% by weight of one or more plant nutrients; and
  - (c) from 1 to 10% of a mixture of one or more cationic emulsifiers including surfactants having cationic characteristics in acidic conditions.
4. An adjuvant according to claim 1 wherein the lipophilic solvent is selected from the group consisting of petroleum fractions, vegetable oils, synthetic triglycerides, alkyl  
20 esters of fatty acids, fatty alcohols, guerbet alcohols or any mixture thereof.
5. An adjuvant according to claim 4 wherein the lipophilic solvent comprises a petroleum fraction.
6. An adjuvant according to claim 5 wherein the petroleum fraction is a mineral oil.
7. An adjuvant according to claim 4 wherein the lipophilic solvent comprises an alkyl  
25 ester of a fatty acid.

8. An adjuvant according to claim 7 where in the fatty acid of the alkyl ester of a fatty acid has a higher level of unsaturation.
9. An adjuvant according to claim 7 wherein the alkyl ester of a fatty acid is derived from natural oils and fats, specific blends produced by fatty acid manufacturers or from fatty acids produced by synthetic means.
10. An adjuvant according to claim 9 wherein the natural oils and fats are selected from the group consisting of lard, tallow, vegetable oils and mixtures thereof.
11. An adjuvant according to claim 1 wherein the plant nutrients comprise one or more ammonium salts of inorganic ions.
12. An adjuvant according to claim 11 wherein the ammonium salts of inorganic ions are selected from the group consisting of ammonium sulfate, ammonium phosphate and mixtures thereof.
13. An adjuvant according to claim 12 wherein the ammonium salt of inorganic ions is ammonium sulfate.
14. An adjuvant according to claim 1 wherein the cationic emulsifiers are selected from fatty amines, fatty amine oxides or mixtures thereof.
15. An adjuvant according to claim 1 wherein the cationic emulsifiers are quaternary cationic emulsifiers.
16. An adjuvant according to claim 1 wherein the cationic emulsifiers are selected from dimethylcocoamine, dimethylaurylamine oxide, alkyltrimethylammonium chloride, alkyl dimethylbenzylammonium chloride, alkylpyridium chloride, alkylimidazolium chloride, or mixtures thereof.
17. An adjuvant according to claim 16 wherein the cationic emulsifiers are selected alkyltrimethylammonium chloride, dimethylaurylamine oxide or mixtures thereof.
18. An adjuvant according to any of the preceding claims further comprising one or more other components to improve the form of the composition.

19. An adjuvant according to claim 18 wherein the other component is selected from nonionic emulsifiers, co-solvents and mixtures thereof.
20. An adjuvant according to claim 18 wherein the other component is a mixture of one or more nonionic emulsifiers.
- 5 21. An adjuvant according to claim 19 wherein the nonionic emulsifiers are selected from the group consisting of alkyl polysaccharides, sorbate emulsifiers, alcohol ethoxylates, fatty alkanolamides or mixtures thereof.
22. An adjuvant according to claim 18 wherein the other component is a co-solvent.
23. An adjuvant according to claim 22 wherein the co-solvent is selected from the  
10 group consisting of propylene glycol, 1,3-butanediol, hexylene glycol, polypropylene glycols, ethanol or mixtures thereof.
24. An adjuvant according to claim 6 wherein the cationic emulsifiers are quaternary cationic emulsifiers.
25. An adjuvant according to claim 24 wherein the nonionic emulsifiers are  
15 alkylpolysaccharides, fatty alkanolamide, sorbitan monooleate or alcohol ethoxylate.
26. An adjuvant according to claim 24 wherein the co-solvents are 1,3-butanediol and ethanol.
27. An adjuvant according to claim 7 wherein at least two cationic emulsifiers are used.
- 20 28. An adjuvant according to claim 27 wherein the mixture of cationic emulsifiers comprises fatty quaternary ammonium chlorides and/or fatty amine oxides in conjunction with fatty alkyldimethylamine salts of simple organic acids.
29. An adjuvant according to any of the preceding claims further comprising one or more other available adjuvant components.

30. An agrochemical composition comprising a chemical used in agriculture and an activity enhancing amount of an adjuvant, said adjuvant comprising:
- (a) not in excess of about 75% by weight of one or more lipophilic solvents;
  - (b) not in excess of about 50% by weight of one or more plant nutrients; and
  - 5 (c) not in excess of about 50% of a mixture of one or more cationic emulsifiers including surfactants which exhibit cationic characteristics in acidic conditions.
31. An adjuvant when used with a chemical used in agriculture comprising:
- (a) not in excess of about 75% by weight of one or more lipophilic solvents;
  - 10 (b) not in excess of about 50% by weight of one or more plant nutrients; and
  - (c) not in excess of about 50% of a mixture of one or more cationic emulsifiers including surfactants which exhibit cationic characteristics in acidic conditions.
32. A method for enhancing the activity of a chemical used in agriculture comprising
- 15 the step of combining the chemical with an adjuvant comprising:
- (a) not in excess of about 75% by weight of one or more lipophilic solvents;
  - (b) not in excess of about 50% by weight of one or more plant nutrients; and
  - (c) not in excess of about 50% of a mixture of one or more cationic emulsifiers including surfactants which exhibit cationic characteristics in
  - 20 acidic conditions.

33. A method of treating vegetation comprising the step of applying an agrochemical composition comprising a chemical used in agriculture and an adjuvant comprising:
- (a) not in excess of about 75% by weight of one or more lipophilic solvents;
  - (b) not in excess of about 50% by weight of one or more plant nutrients; and
  - 5 (c) not in excess of about 50% of a mixture of one or more cationic emulsifiers including surfactants which exhibit cationic characteristics in acidic conditions.

## INTERNATIONAL SEARCH REPORT

 International application No.  
**PCT/AU00/00416**

<b>A. CLASSIFICATION OF SUBJECT MATTER</b>		
Int. Cl. <sup>7</sup> : A01N 25/30, 25/02, 57/20		
According to International Patent Classification (IPC) or to both national classification and IPC		
<b>B. FIELDS SEARCHED</b>		
Minimum documentation searched (classification system followed by classification symbols) IPC:A01N 25/30,25/02,25/22,57/-,27/-		
Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched		
Electronic data base consulted during the international search (name of data base and, where practicable, search terms used) WPAT: IPC as above		
<b>C. DOCUMENTS CONSIDERED TO BE RELEVANT</b>		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
P,X	WO 99/51099 A (MONSANTO COMPANY) 14 October 1999 Pages 9-11	1-3,11-13,18-21,25,29-33
X	EP 598 515 A (ISHIHARA SANGYO KAISHA LTD.) 25 May 1994 Page 6	1-5,11,12,18-20,22,29-33
Y	EP 598 404 A (KUMIAI CHEMICAL INDUSTRY CO.) 25 May 1994 Whole document	1-33
<input checked="" type="checkbox"/> Further documents are listed in the continuation of Box C <input checked="" type="checkbox"/> See patent family annex		
* Special categories of cited documents: "A" document defining the general state of the art which is not considered to be of particular relevance "E" earlier application or patent but published on or after the international filing date "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) "O" document referring to an oral disclosure, use, exhibition or other means "P" document published prior to the international filing date but later than the priority date claimed "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art "&" document member of the same patent family		
Date of the actual completion of the international search <b>21 June 2000</b>		Date of mailing of the international search report <b>04 JUL 2000</b>
Name and mailing address of the ISA/AU AUSTRALIAN PATENT OFFICE PO BOX 200, WODEN ACT 2606, AUSTRALIA E-mail address: pct@ipaustalia.gov.au Facsimile No. (02) 6285 3929		Authorized officer  <b>GAYE HOROBIN</b> Telephone No : (02) 6283 2069

## INTERNATIONAL SEARCH REPORT

International application No.

PCT/AU00/00416

C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	WO 97/00010 A (MONSANTO COMPANY) 3 January 1997 Whole document	1-33
Y	US 5 672 564 A (BASF AKTIENGESELLSCHAFT) 30 September 1997 Whole document	1-33
Y	EP 358 494 A (DOW CHEMICAL COMPANY LIMITED) 14 March 1990 Whole document	1-33
Y	EP 554 015 A (ISHIHARA SANGYO KAISHA, LTD.) 4 August 1993 Whole document	1-33



**INTERNATIONAL SEARCH REPORT**  
Information on patent family members

International application No.  
**PCT/AU00/00416**

This Annex lists the known "A" publication level patent family members relating to the patent documents cited in the above-mentioned international search report. The Australian Patent Office is in no way liable for these particulars which are merely given for the purpose of information.

Patent Document Cited in Search Report				Patent Family Member			
WO	99/51099	AU	337733/99				
EP	598515	BG	98226	BR	9304750	CN	1089431
		HU	65440	JP	6340509	MX	9307176
EP	598404	BR	9304763	CN	1086955	JP	6157209
		LT	1453	US	5436225	US	5510321
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		CN	1126422	DE	4322211	EP	707445
EP	358494	GB	8820886				
EP	554015	PL	297553	BR	9300297	CA	2087930
		CN	1075846	HU	63937	MX	9300471
		US	5411932	JP	6040823		
END OF ANNEX							